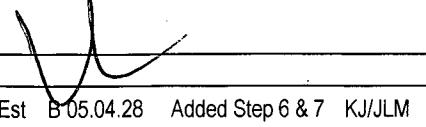
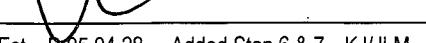


ASAP

Date: Monday, 05/11/2007 10:52:28 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: FRAME		
Job Number	: 35480		Part Number	: D32401		
Estimate Number	: 10644		Drawing Number	: D3240 REV B		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 05/11/2007 S.O. No. : N/A		Drawing Revision	: B		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 12/11/2007 Qty: 8 Um: Each		
Previous Run	: 35480					
Written By	: 					
Checked & Approved By	: 					
Comment	: Est B 05.04.28 Added Step 6 & 7 KJ/JLM Est Rev C now water jet 07-11-01 DD					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S063	2024-T3 .063 sheet
Comment: Qty.: 2.6607 sf(s)/Unit Total : 21.2856 sf(s) 2024-T3 aluminum sheet .063 thick Batch: <u>106223</u> <u>WB 07-11-12</u>		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D3240 Dwg Rev: <u>B</u> <u>WB 07-11-12</u> Prog Rev: <u>B</u>		
2-Deburr if necessary <u>WB 07-11-12</u>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
<u>WB 07-11-12</u> Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK
<u>WB 07-11-12</u> Comment: SECOND CHECK		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
<u>WB 07-11-12</u> Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr if necessary		

Date: Monday, 05/11/2007 10:52:28 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FRAME

Job Number: 35480

Part Number: D32401

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

48

07-11-21

48

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M.F. 07/11/21

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 272A

11/11/22 50 8X

9.0 QC21

FINAL INSPECTION/W/O RELEASE



8

Comment: FINAL INSPECTION/W/O RELEASE

11/11/22 50 8X

Job Completion



11/11/22

Date: Wednesday, 10/31/2007 3:26:18 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	: FRAME		
Job Number	35480			Part Number	: D32401		
Estimate Number	10644			Drawing Number	: D3240 REV B		
P.O. Number	:			Project Number	: N/A		
This Issue	10/31/2007	S.O. No.	:	Drawing Revision	: B		
Prsht Rev.	NC			Material	:		
First Issue	/ /	Type	PURCHASED PARTS	Due Date	11/20/2007	Qty:	8 Um: Each
Previous Run	:						
Written By	:						
Checked & Approved By	:						
Comment	Est	B 05.04.28	Added Step 6 & 7	KJ/JLM			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING

Issue P/O: _____

Email or Ship DXF file to vendor

Laser Cut flat pattern per Dwg D3240

Possible Supplier: GFI

Material release note is required

2.0	D32401F	Frame
-----	---------	-------



Comment: Qty.: 1.0000 U(s)/Unit Total : 8.0000 U(s)

Frame

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: DIMENSIONAL CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FRAME

Job Number: 35480

Part Number: D32401

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

9.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

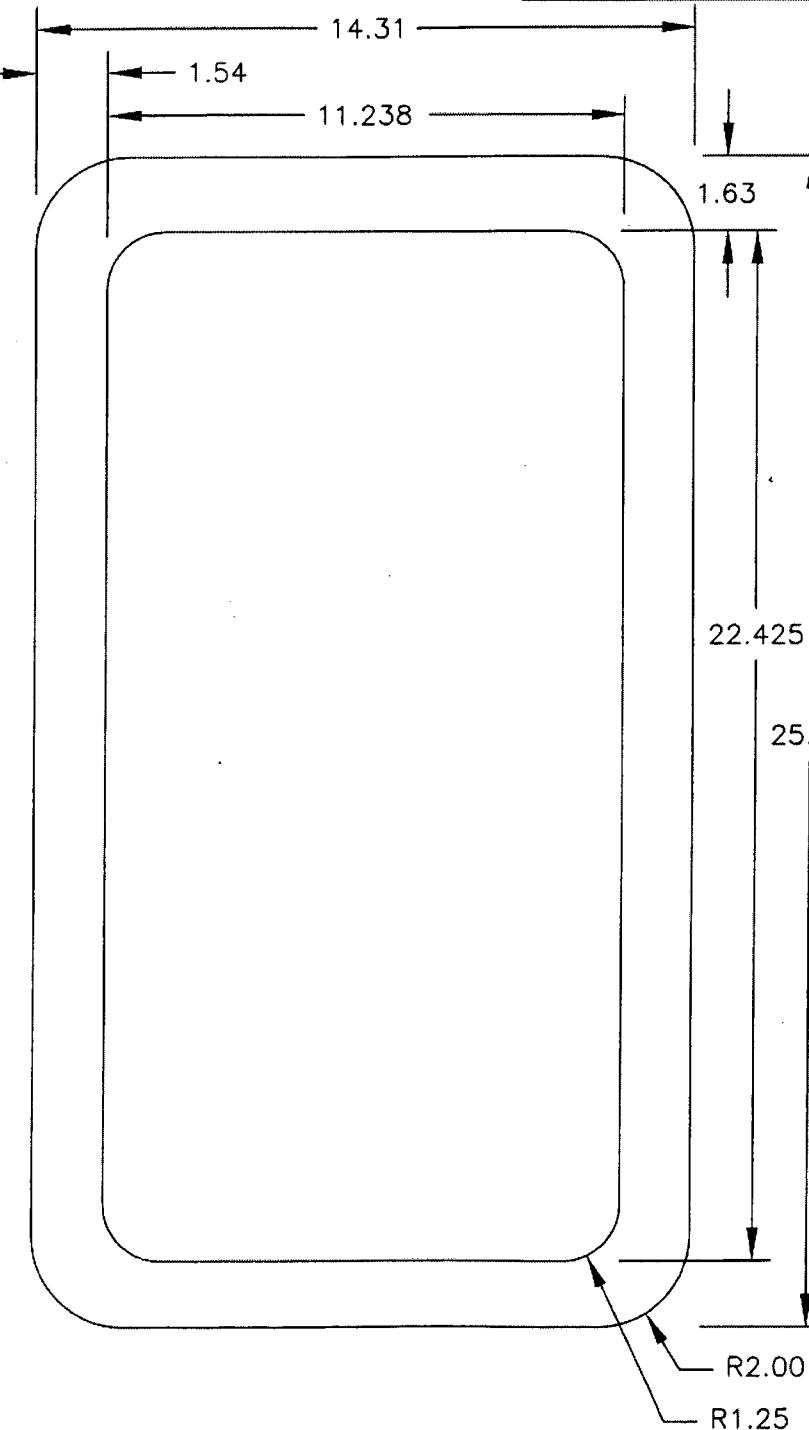
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3240 REV. B SHEET 1 OF 1
DATE		TITLE FRAME SCALE
05.01.06		NTS
A	03.12.18	NEW ISSUE
B	05.01.06	25.50 WAS 25.19; 14.31 WAS 14.19



RELEASED
05-02-02

D3240-1 FRAME

- 1) MATERIAL: 2024-T3 (QQ-A-250/4), 0.063 THICK (REF. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 35480

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DART AEROSPACE LTD	Work Order:	35480
Description: FRAME	Part Number:	D3240-1
Inspection Dwg: D3240-1 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Measured by:	HB	Audited by:	/	Prototype Approval:	NIA
Date:	07-11-17	Date:	07-11-15	Date:	/

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

10